Work Order ID 57349 April 6, 2010 8:20:17 AM Page 1 Item ID: D3670-4-200 Accept Setup Start Revision ID: Item Name: SPACER Stop Start Date: 06/04/2010 Start Qty: 100.00 Cust Item ID: Required Date: 09/04/2010 Req'd Qty: 100.00 Customer: Reference: Approvals: Process Plan: Start Run Tooling: Date: QC: Date: Stop SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Draw Plan Accept Reject Work Center ID Reject Description Insp. **Run Hours** Number Rev. Code Qty Qty Number Stamp Draw Nbr Revision Nbr D3670 Rev A 100 0.00 Hardinge CNC LATHE SMALL Hardinge Memo 0.00 Hardinge CNC Lathe Small 1-TURN AS PER FOLIO FA711& DWG D3670 FOLIO REV: 2-DEBURR AS REQUIRED 10/04/06 110 QC2- Inspect parts off machine FAI/FAIB 0.00 Memo Quality Control 51 10/04/06 120 QC8- Inspect parts - second check 0.00

0.00

QC

Quality Control

Memo

Dart	Aeros	pace	td
Duit	70103	Ducc	

W/O:			W	ORK ORDER CHAN	GES					4
DATE	STEP	PR	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:								
Resolution: Disposition:					QA	N/C Cld	osed:		Date: _	
NCR:			WORK ORE	DER NON-CONFORM	IANCE	(NCR	)			
DATE STEP		Description of NC Corrective Action			ction B		Verific	ation	Approval	Approval
DAIL	SILP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
					-					
								11.5	Sec. 19	

## Work Order ID 57349

April 6, 2010 8:20:17 AM



Page 2

Item ID:

D3670-4-200

Accept

Setup Start

Stop

Revision ID:

Item Name: SPACER

Required Date: 09/04/2010

Start Date:

06/04/2010

Start Qty: 100.00

Req'd Qty: 100.00

Cust Item ID:

Customer:

Draw

Number

Approvals:

Reference:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

Packaging

Packaging

Quality Control

Operation Description

Identify as per dwg & Stock Location:

Memo

Set Up/ Run Hours

0.00

0.00

Draw Rev.

Accept Qty

Plan

Code

Reject Qty

Reject Number Stamp

Insp.

140

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

95

BS 10-4-13

Dart Aerosp	ace	Ltd
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W/O:			V	ORK ORDER CHANG	ES				4
DATE	STEP	PROCEDURE CHANGE By Date Qty						Approval Chief Eng / Prod Mgr	Approval QC Inspector
									4
Part No		PAR #:							
	R	esolution:						Date: _	
NCR:		-	WORK ORI	DER NON-CONFORM	ANCE (NCR	)			75 1 1 20 0
DATE	STEP	Description of NC Section A  Corrective Action Section Initial Action Description				Cian e Verific			Approval
		Section A	Chief Eng	Chief Eng	Date	Section	on C	Chief Eng	QC Inspector
								9	1

### **Picklist Print**

April 6, 2010 8:20:21 AM

Work Order ID: 57349

Parent Item: D3670-4-200

Parent Item Name: SPACER

Comments:

Item Name

Component Item ID/ Replacement Mfg/ Item ID

Purch Purchased

Bin Primary Item Location No

Last Location

Route Seq ID

Unit of Qty on Measure Hand

Remaining 36.0000

Loc Code

Qty To Pick Issued 36.0180

Qty

Start Date: 06/04/2010

Start Qty: 100.00

Date

Status Issued

Required Date: 09/04/2010

Required Qty: 100.00

Page 1

M6061T6T0.3125W.05

ALUM TUBE .3125 x .058w

Loc Qty

Location Main Warehouse

Warehouse

MAT013

112142

36 36

f

36F+ 51,00406

Duit Aciospace Liu	Dart	Aeros	pace	Ltd
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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										11 -		
Part No		PAR #:										
	Resolution: Disposition:				QA: N/C Closed: Date:							
NCR:		1	WORK ORI	DER NON-CONFORMA	NCE	(NCR	)					
DATE STEP		Description of NC			Section B			ation	Approval	Approval		
	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector		
										-b		

DART AEROSPACE LTD	Work Order:	57344		
Description: Spacer	Part Number:	D3670 4200		
Inches de la Constantina del Constantina de la Constantina del Constantina de la Con	r art Number.	D3670-4200		
Inspection Dwg: D3670 Rev: A	1 1 1 1 1 1 1	Page 1 of 1		

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	C	omments
Ø0.313	+/-0.010	0.310	/			1 1	10/10
Ø0.197	+/-0.010	9,198	_		177		
4.200	+/-0.010	4,200					
0.060	+/-0.010	.060	-				
R0.03	+/-0.030	12.032					
0.015	+/-0.010	.012	/				
						77	
		1 5 F 3					
		11, 2, 16, 1					EXEC
							BEE
							2.7
							187
							- 4
			- 2-3				
sured by:	17	Audited by:	mb=		Drotot:		
	0/04/06	1	0/04/00		Prototype Ap	Date:	N/A N/A
	Change		1/00		English a	Date.	IN/A

H:\FORMS\Quality Assurance\approved	QA\FAI revD
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### **Dart Aerospace Ltd**

W/O:			WC	RK ORDER CHANG	ES		1		14-		
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No		PAR #:									
	He	esolution:						_ Date: _			
NCR:		9 20		R NON-CONFORMA	ANCE (NCH	()					
DATE	STEP	Description of NC	Initial	Corrective Action Section	S STANFACE	Verification				Approval	Approval
	Hip. F.	Section A	Chief Eng	Action Description Chief Eng	Date	Section	1 C	Chief Eng	QC Inspector		
								<u>.</u>			
							100				
	ē										

# SPECIFICATION CONTROL DRAWING

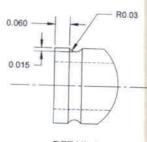
Ø0.313 (STOCK, REF) Ø0.197 (STOCK, REF)

SEE DETAIL A LENGTH (REF)

4.200

SPECIFICATION: D3670-XXXX SPACER LENGTH

WHERE XXXX IS LENGTH IN INCHES EG: 3.750" LONG SPACER: D3670-3750



DETAIL A (SCALE 4:1)

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

RELEASED

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-220/8 (REF. DART SPEC. M6061T6T0.313W.058)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 3) TOLERANCES. PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: NONE 7) WEIGHT: N/A

A NEW ISSUE DC: 07.10.19 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A MFG APPR D3670 SHEET 1 OF APPROVED TITLE SCALE DE APPR SPACER COPYRIGHT © 2007 BY DART A EROSPACE LTD
HOT TO BE USED FOR ANY PARKETS AND TO THE ENTREES OF 2:1 DATE 07.10.19

Dart Aerospa	ace l	_td
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W/O:			W	ORK ORDER CHANG	SES					3
DATE	STEP	PRO	PROCEDURE CHANGE By Date					Qty	Approval QC Inspector	
									34	
Part No		PAR #:								
Resolution: Disposition:					_ QA: N/C	Clos	sed:		_ Date: _	
NCR:		V	ORK OR	DER NON-CONFORM	ANCE (N	CR)				+
DATE STEP		Description of NC	Description of NC			tion B			Approval	Approval
	O I E I	Section A		Initial Action Description Chief Eng Chief Eng		ın & ate	Section C		Chief Eng	QC Inspector
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